



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

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D2858-2
Job Sheet 212568



Part No: D2858-2

Job Qty: 18 pcs

Part Name: Hinge Bracket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/26/20

Job Tracking No:

Due Date: 9/30/20

Created By: Marie Lajeunesse

Type: Stock

Description: SIOP

Note: DWG REV C IPP C 00.06.22 Removed P/O for powder coat EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	16 pcs	9/29/20	9/29/20	0.00	0.05	Bandsaw - 1		mf 20/09/13
110	HAAS 4 Axis - B4B	16 pcs	9/29/20	9/29/20	1.00	4.39	HAAS - 1 - B4B		
							HAAS - 2 - B4B		DAS
							HAAS - 3 - B4B		33 20/09/12
							HAAS - 4 - B4B		9-89
130	QC 8	16 pcs	9/29/20	9/29/20	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		De 20-09-15
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		



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Container No: S300198



Part: D2858-2

Job No: 212568

Serial No/Batch: S300198

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 09/14/20

140	Handfinish - 1-1 Chemical-B4B	16 pcs	9/29/20	0.00 0.31	QC 8 - 76	
					QC 8 - 61	
					QC 8 - 66	
					QC 8 - 73	
					QC 8 - 82	
					Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
150	Powdercoat - 1 White Gl(A)-B4B <i>M 254469.</i>	16 pcs	9/30/20	0.00 0.27	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	
					Powdercoat - 5 - B4B	
					Powdercoat - 6 - B4B	
					Powdercoat - 7 - B4B	
					Powdercoat - 8 - B4B	
					Powdercoat - 9 - B4B	
					Powdercoat - 10 - B4B	
160	QC 3	16 pcs	9/30/20	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	

JW 2020/09/16

20-09-16

34 9:39

START: 1:30

O.V.T. 320°

FINISH: 2:00

					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	DAS
					QC 3 - 61	82
					QC 3 - 81	9-89
					QC 3 - 82	SEP 16 2020
					QC 3 - 87	
					QC 3 - 47	
170	Packaging 3-1 - Stock - B4B	16 pcs	9/30/20	0.00 0.00	Packaging 3 - 1 - B4B	
		18 pcs mjd			Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	DAS
					Packaging 3 - 7 - B4B	28
					Packaging 3 - 8 - B4B	9-89
					Packaging 3 - 9 - B4B	SEP 17 2020
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					Packaging 3 - 37 - B4B	

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8/26/2020

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

DAS

21

9-09

SEP 17 2020

180 QC 21 - SA

16
pcs

9/30/20

0.00 0.00

QC 21 - SA - 21

QC 21 - SA - 70

Broussard

QC 21 - SA - 9

QC 21 - SA - 77

Part Op 100 - -Cut blanks at 5.85" -1 blank makes 3 parts.
 Descriptions: 110 - HAAS CNC Vertical Machine 1-Machine per folio FA941
 130 - QC8- Inspect parts - second check
 140 - Chemical Conversion Coat per QSI005 4.1
 150 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____
 160 - QC3- Inspect Part Finish
 170 - Identify as per dwg & Stock Location: _____
 180 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.250X1.500	6061-T6 Bar 1.250 X 1.500	2.4000 ft (.15 ea)	100-Bandsaw - 1	S168970X3 S195466X3

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B1.250X1.500	2	14	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Hinge Bracket	0.171inches + 0.005 - 0.000	0.172 0.171		
2	Hinge Bracket	0.400inches + 0.005 - 0.000	0.402 0.400		
3	Hinge Bracket	0.125inches ± 0.010	0.125 0.135 0.115		
4	Hinge Bracket	0.328inches ± 0.010	0.329 0.338 0.318		
5	Hinge Bracket	0.820inches ± 0.010	0.820 0.830 0.810		
6	Hinge Bracket	1.476inches ± 0.010	1.475 1.486 1.466		
7	Hinge Bracket	0.342inches ± 0.010	0.342 0.352 0.332		
8	Hinge Bracket	0.875inches ± 0.010	0.875 0.885 0.865		
9	Hinge Bracket	1.560inches ± 0.030	1.562 1.590 1.530		
10	Hinge Bracket	0.147inches ± 0.010	0.147 0.157 0.137		
11	Hinge Bracket	0.717inches ± 0.010	0.717 0.727 0.707		
12	Hinge Bracket	0.697inches ± 0.010	0.697 0.707 0.687		
13	Hinge Bracket	0.229inches ± 0.010	0.231 0.239 0.219		
14	Hinge Bracket	0.125inches ± 0.010	0.125 0.135 0.115		
15	Hinge Bracket	0.063inches ± 0.010	0.063 0.073 0.053		
16	Hinge Bracket	0.063inches ± 0.010	0.063 0.073 0.053		
17	Hinge Bracket	0.126inches ± 0.010	0.124 0.136 0.116		
18	Hinge Bracket	0.630inches ± 0.010	0.630 0.640 0.620		
19	Hinge Bracket	0.354inches ± 0.010	0.354 0.364 0.344		
20	Hinge Bracket	0.965inches ± 0.010	0.958 0.975 0.955		
21	Hinge Bracket	0.166inches + 0.005 - 0.000	0.167 0.171 0.166		

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					